

Date: Tuesday, 11/21/2006 1:35:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 29618		
Estimate Number	: 12437		
P.O. Number	: N/A	Part Number	: D35181
This Issue	: 11/21/2006 S.O. No. : N/A	Drawing Number	: D3518 PRELIMINARY B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A PRELIMINARY B
Previous Run	: 27983	Material	: N/A
Written By	: <u> </u>	Due Date	: 12/5/2006
Checked & Approved By	: <u> </u>	Qty:	12 Um: Each
Comment	: Est Rev:A New Issue 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6H0875	6061-T6 7/8" HexBar
-----	--------------	---------------------



Comment: Qty.: 1.1550 f(s)/Unit Total: 13.8600 f(s)
 6061-T6 7/8" HexBar
 Batch: 1101694

MS/JS 06/11/22

2.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE
 Turn as per Dwg D3518,

1-Face to Length and Drill & Tap.

MS/JS 06/11/22 8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/JS 06/11/22 8

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Drill as per Dwg D3518.

1-Drill 2x .191" holes & 1x .0625" hole

MS 06/11/25 8

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/11/25 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:35:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 29618

Part Number: D35181

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/11/20 8

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Y/au 06/11/30 X8

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

fc 06/12/01 8

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAN 06/12/02 8

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SAN 06/12/02 8

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/04 8

Job Completion



u 06.12.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

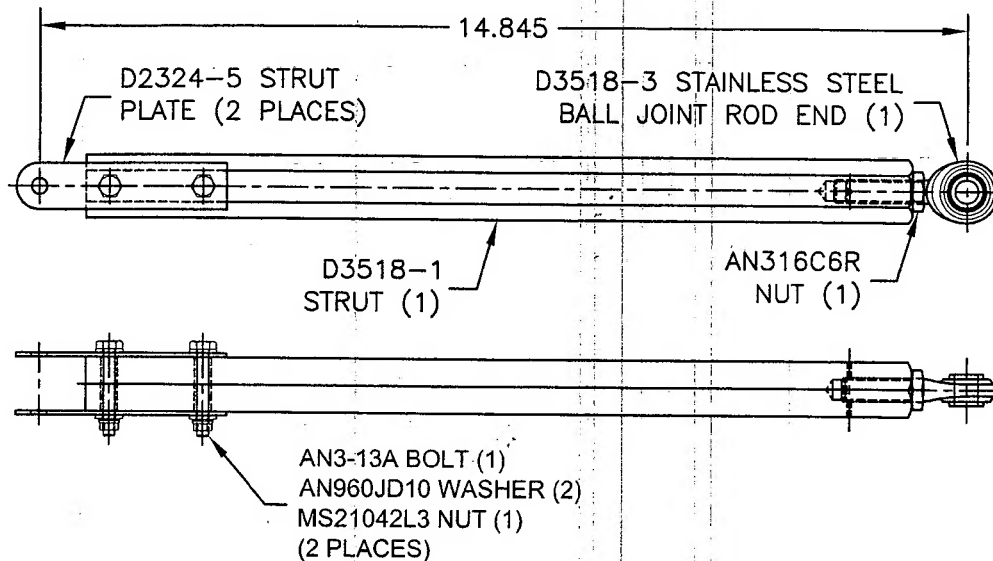
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



D3518-041 STRUT ASSEMBLY

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

RELEASED

06.11.17

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

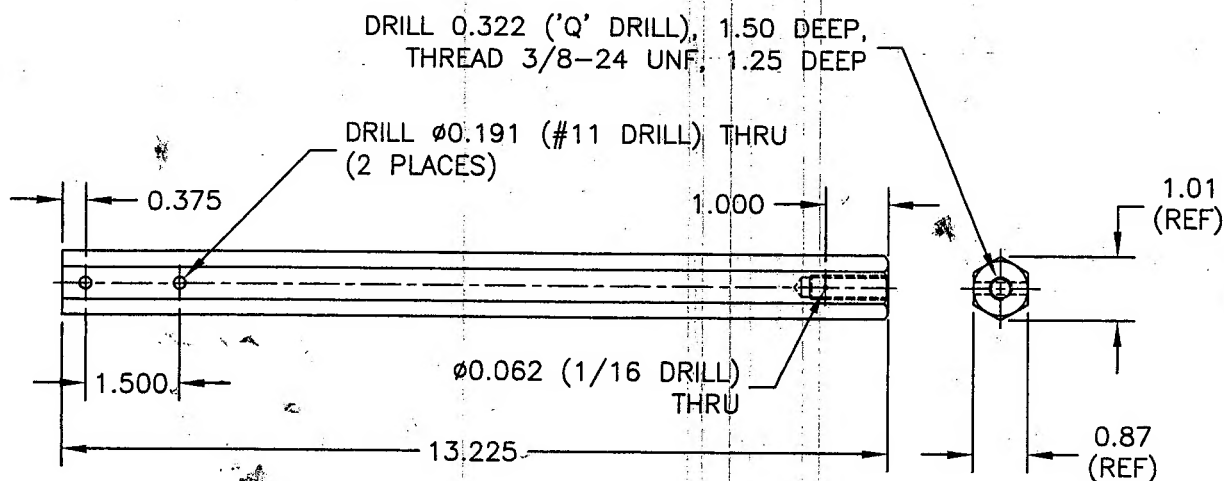
21225

9

10



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3



D3518-1 STRUT

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. *29618*

RELEASED

06.11.17 *[Signature]*

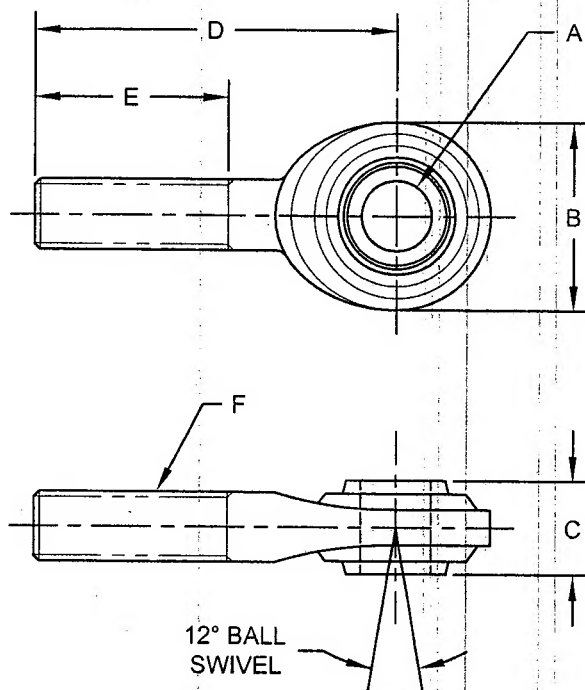
Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT SCALE 1:1	

SPECIFICATION CONTROL DRAWING



DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROBE END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

NO. 29618
06.11.17 *[Signature]*

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

4410169